



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G26551-3G-1
Job Sheet 176053



Part No: RBW6205G26551-3G-1

Job Qty: 6 ea

Part Name: Main Rotor Scissor Locknut



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 4/16/18

Job Tracking No:

Due Date: 7/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G26551-3G Rev B IPP Rev A 18.01.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/9/18	7/9/18	0.00	0.00	Start Up Machining-3		JK
110	CNC Lathe	6 pcs	7/9/18	7/9/18	0.00	6.00	MORI SL2500Y		JK J.C.
120	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC2 Machining-4		JK
130	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC8 Machining-4		B. 18-07-16
140	Packaging	6 pcs	7/9/18	7/9/18	0.00	0.00	Packaging3-1		ALC
150	QC21-SA	6 Ea	7/9/18	7/9/18	0.00	0.00	QC21		JUL 17 2018

Part Op 110 - 1-Machine as per DWG. FB731 FOLIO REV: AA DWG REV: B 2-Deburr 3-Broach as per Descriptions: DWG. 4-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.375	17-4 SS H900 Round Bar 1.375"	.7140 ft (.119 ea)	90-Start up Operation	M126952-.66

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R1.375	1	5	0

Part Specifications

Specifications could not be found.

Plex 7/10/18 4:39 PM dart.logan.david



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Container No: S092432



Part: RBW6205G26551-3G-1

Job No: 176053

Serial No/Batch: S092432

Revision: B

Inspector:

Exp Date:

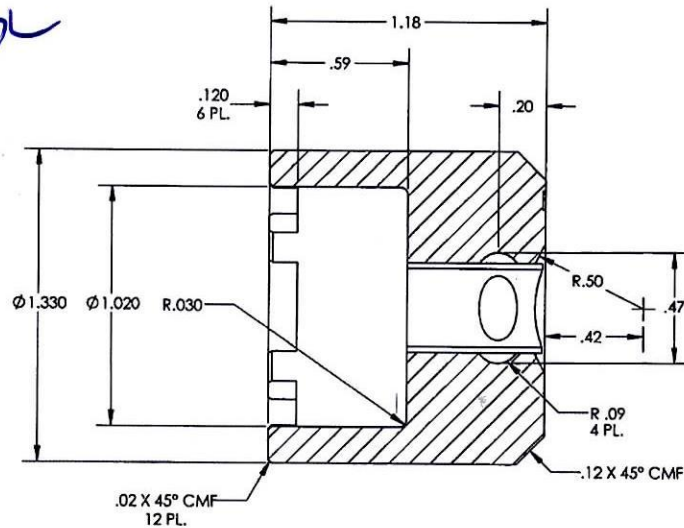
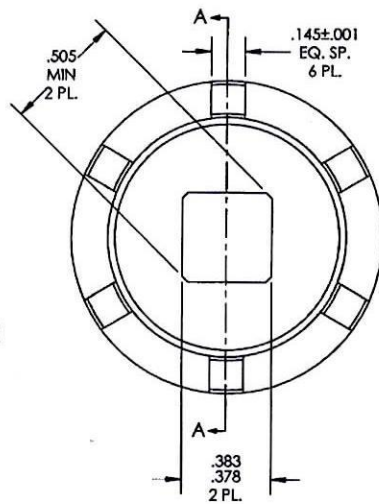
Instructions:

Date: 07/16/18

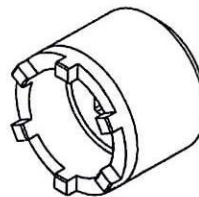
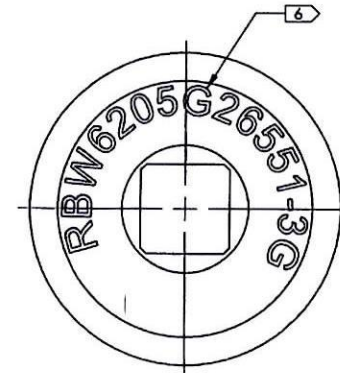
SAFETY COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

176053
20180710
7L

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
B	ENGRAVE CHANGED FOR MACHINE ENGRAVE, TEMPLATE UPDATED, DIMENSION 145 CHANGED FOR .145 +/- .001, CAD PLATE YELLOW CHANGED FOR ZINC PLATE (SPEC UPDATED), MATERIAL 4140/4142 Q&T UPDATED FOR 4140/4142 (28-32 Rc)	17-796	17.12.20	VM	ML



SECTION A-A



RBW6205G26551-3G-1 M/R SCISSOR LOCKNUT

NOTES:

- 1) MATERIAL: 17-4 PH-H900 SS
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE T/N AS SHOWN, 0.010" DEEP

DART AEROSPACE Newbury, Ontario, Canada	
TITLE M/R SCISSOR LOCKNUT	
PART NO. RBW6205G26551-3G-1	REV B
TOOL NO. RBW6205G26551-3G	
INITIALS AND DATE	
DESIGNED BY: VM 17/12/20	TOLERANCES: UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING
DRAWN BY: VM 12/20/2017	FRACTIONS: 2/16
CHECKED BY: ML 12/21/2017	ANGLES: 2.0°
MFG REVIEW BY: DD 01/02/2018	SURFACE: X 2.1
APPROVED BY: ML 01/04/2018	ROUGHNESS: X 2.1
SCALE: NTS SHEET 2 OF 6	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					